

Work Order ID 58185

April 27, 2010 1:43:26 PM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 27/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 04/05/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan:

*RL*Date: 10-11-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr	
D3910	B	

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut to 1.450" Long

0.00

*mf 10-5-3**24*

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV: *AA*
DWG REV: *AA*

0.00

mf 10-5-3

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Qty

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

10/05/03

24

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

10/05/03

24

10-5-3

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Page 3

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

150

Memo

START: 7:30AM
Temp: 320°F
FIN: 8:00AMSet Up/
Run Hours

0.00

Draw
Number

10105/04

Draw
Rev.

0

Plan
Code

24

Accept
Qty

24

Reject
Qty

0

Reject
Number

0

Inspec.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

24 BK 10-5-4.

170



Packaging

Packaging

Identify as per dwg & Stock Location: 50F

0.00

Memo

0.00

10-5-4 - 50F SF

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NOTE: Date & initial all entries

Picklist Print

April 27, 2010 1:43:30 PM

Page 1

Work Order ID: 58185



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 27/04/2010

Required Date: 04/05/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	517.9499	3.2842			

Lug Extrusion

Warehouse
Location

Main Warehouse

MAT06 517.9499

43722 180

45800 517.9499

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DART AEROSPACE LTD	Work Order:	58185
Description: Crosstube Lug	Part Number:	D3910-3
Inspection Dwg: D3910	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	Audited by:	Preliminary Approval:
Date: 10-5-02	Date: 10/25/03	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	 

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

D

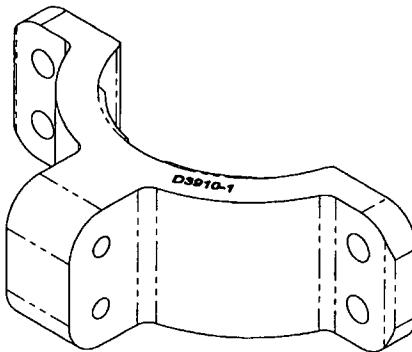
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C

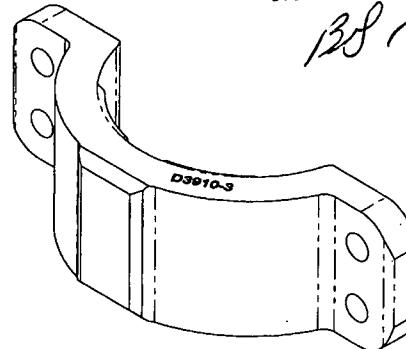
C

B

B



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58185

1810-4-27

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	$\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	J	DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED	JW	TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

1

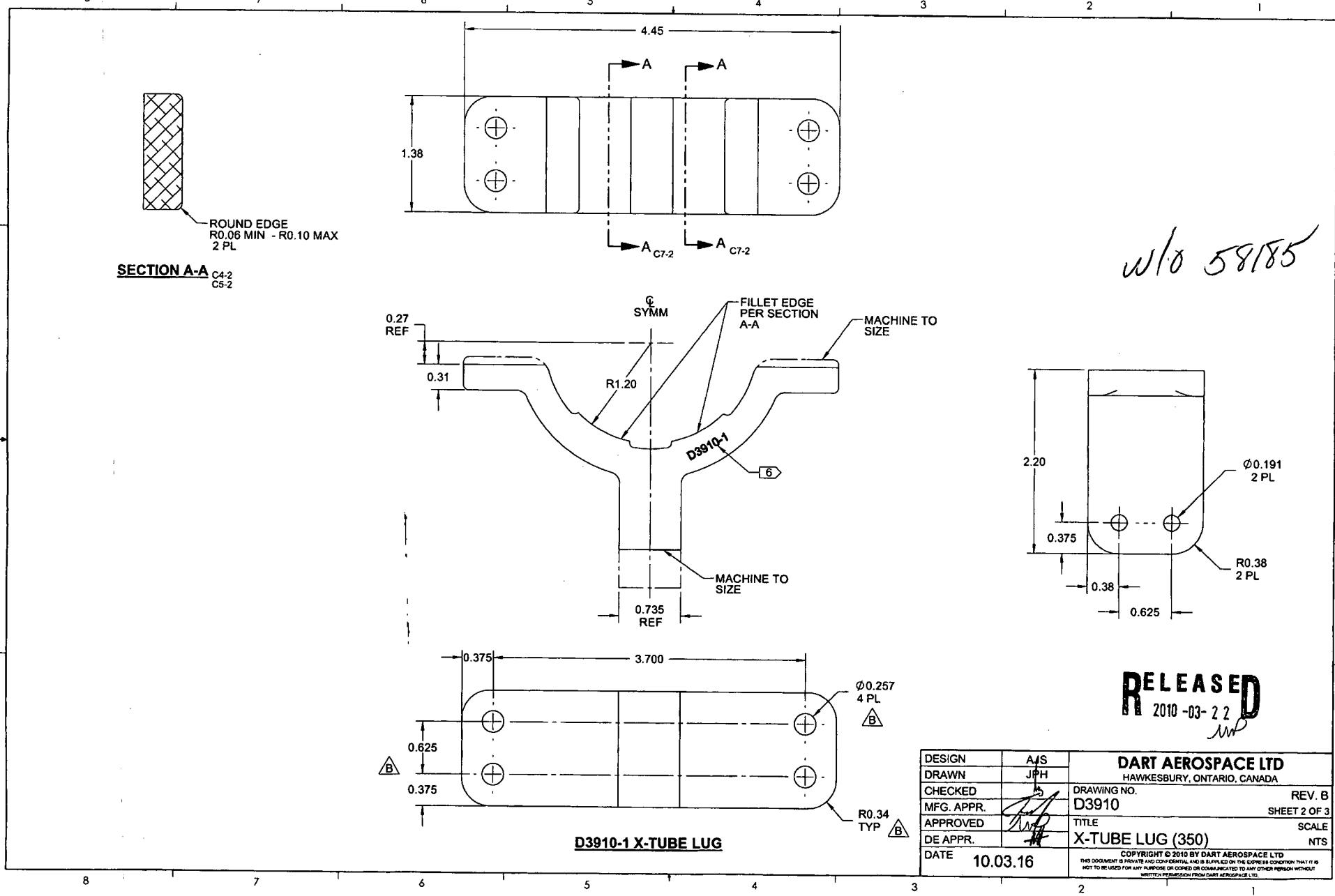
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W/0 58185

RELEASED
2010-03-22
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPB		
CHECKED	S	DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
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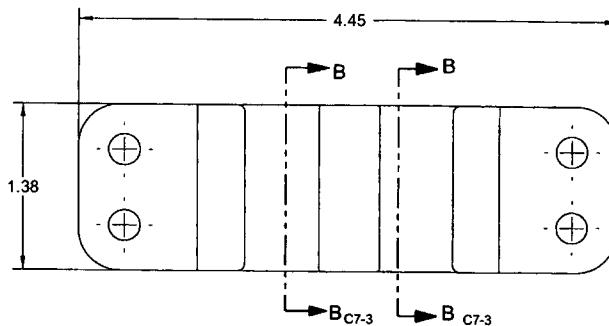
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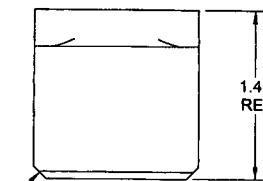
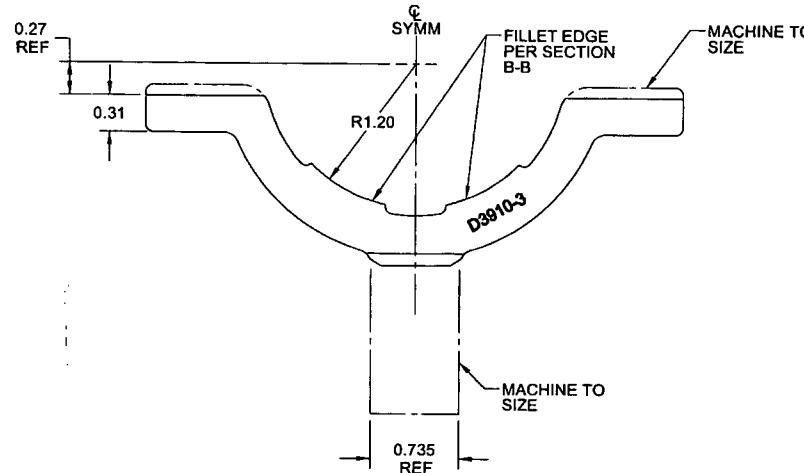


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

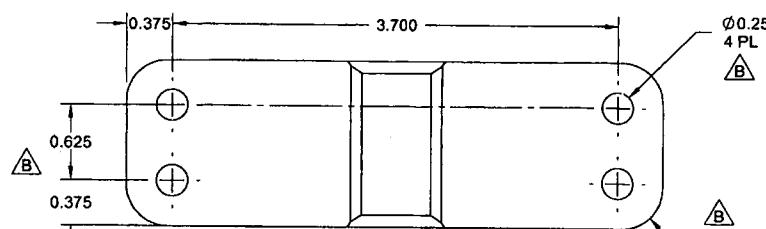
SECTION B-B C4-3
C5-3



Wb 58185



0.100 X 45° C



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
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